

Date: Tuesday, 12/13/2005 11:46:13 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG
Job Number	: 23479		
Estimate Number	: 10337		
P.O. Number	: N/A	Part Number	: D28073
This Issue	: 12/13/2005 S.O. No. : N/A	Drawing Number	: D2807 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11/14/2005 Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	: N/A	Material	: N/A
Written By	: <u>See comment below</u>	Due Date	: 12/15/2005
Checked & Approved By	: <u>See comment below</u>	Qty:	100 Um: Each
Comment	: Est A 05.06.02 New Issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M303R0750	303 Round Bar .75"
Comment: Qty.: 0.1094 f(s)/Unit Total : 10.9410 f(s) Material: 303 Round Bar Ø0.750" (M303R0.750) Batch: <u>M19296</u>		
		<u>M8 05/12/15</u>
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
Comment: HARDINGE Turn as per Folio FA529 and Dwg D2807 Dwg Rev: <u>C</u>		
		<u>M8 05/12/15</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
		<u>M8 05/12/15</u>
4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr		
		<u>M8 05/12/16</u>
5.0	BAND SAW	BAND SAW
Comment: BAND SAW <u>HAAS</u> Machine as per Folio FA528 and Dwg D2807 Dwg Rev: <u>C</u> Folio Rev: <u>AA</u>		
		<u>JL 06.01.08 98</u>

Date: Tuesday, 12/13/2005 11:46:13 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 23479

Part Number: D28073

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.1 06.01.08 98

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

5.40 06/01/08 98

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5.40 06/01/08 98

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 379

CL 06/01/09 98

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

5.45 06/01/10 98

06/01/10

98

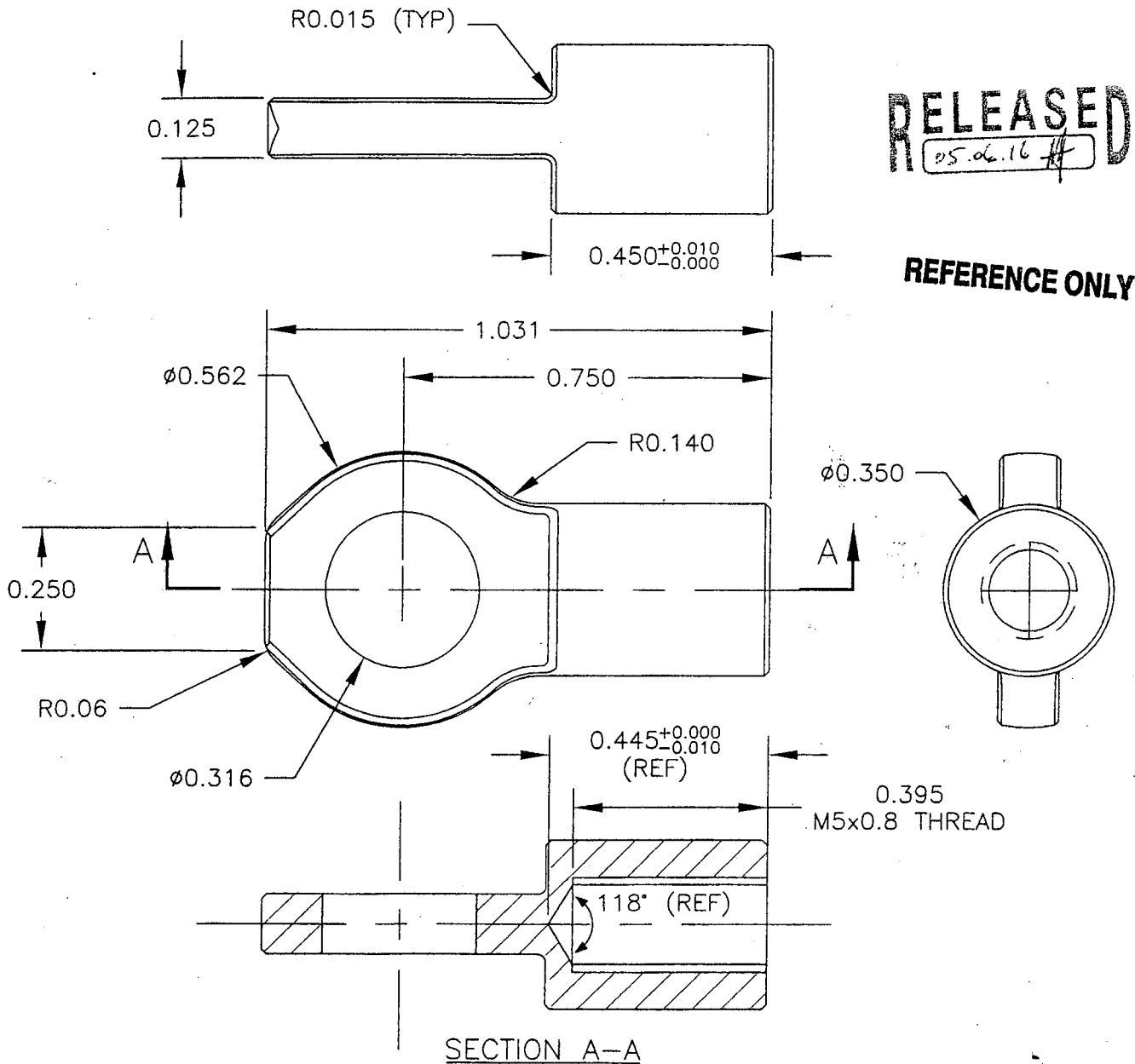
Job Completion



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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2807	REV. C SHEET 2 OF 2
DATE 05.05.25	TITLE GAS SPRING		SCALE 3:1



RELEASED
05.06.16 #

REFERENCE ONLY

D2807-3 LUG

- 1) MATERIAL: AISI 303 ROUND BAR (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.015
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE LTD		Work Order:	23479
Description: Gas spring		Part Number:	2807
Inspection Dwg:	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.125	$\pm .010$					
$\phi .562$	$\pm .010$	$\phi .561$	✓			
.250	$\pm .010$.251	✓			
R.140	$\pm .010$					
$\phi .350$		$\phi .352$	✓			
.750	$\pm .010$.750	✓			
1.031	$\pm .010$	1.034	✓			
.445	$\pm .000$	0.443	✓			
max thread .395 depth	$\pm .010$	0.390	✓			
$\phi .316$	$\pm .010$.318	✓			
R.015	$\pm .010$.015	✓			
R.06	$\pm .010$.060	✓			
.125	$\pm .010$.125	✓			
.750	$\pm .010$.748	✓			
.450	$\pm .010$.454	✓			

Measured by: MR	Audited by: gml	Prototype Approval: N/A
Date: 05/12/15	Date: 05/12/15	Date: N/A


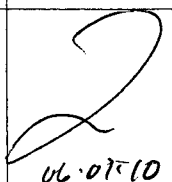

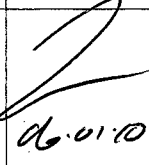




Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/12/15	2	10 pieces scrap		destroy and replace	J.L. 06-01-08	 06-01-10		 06-01-10
06-01-08	5	- 2 parts scrapped error in pgm		- destroy	J.L. 06-01-08	 06-01-10		 06-01-10

NOTE: Date & initial all entries

5/23

DART AEROSPACE LTD	Work Order:	23479
Description: Lug	Part Number:	D2807-3
Dwg: D2807 Rev. B page 2	Qty:	100
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	JG	05.06.06	100
2	MC	Turn as per Folio FA529 and Dwg D2807 Material: 303 Round Bar Ø0.750" (M303R0.750)	JG	05/06/06	100
3	QC2	Inspect parts as they come off the machine	JG	05/06/06	100
4	MC	Deburr			
5	MV	Machine as per Folio FA528 and Dwg D2807	JL	05/06/10	100
6	QC2	Inspect parts as they come off the machine	JL	05/06/10	100
7	MV	Deburr	JL	05/06/10	100
8	QC8	Second check			
9	ST	Identify and Stock			
10	AC	Cost / part: _____			
11	DC	Close W/O Inspect Level 21			

Rev	Date	Change	Revised By	Approved
A	05.06.02	New Issue	KJ/JLM	[Signature]

RELEASED
05/06/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
		Some parts are too short! from 0.090" to 0.010" Qty 5						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

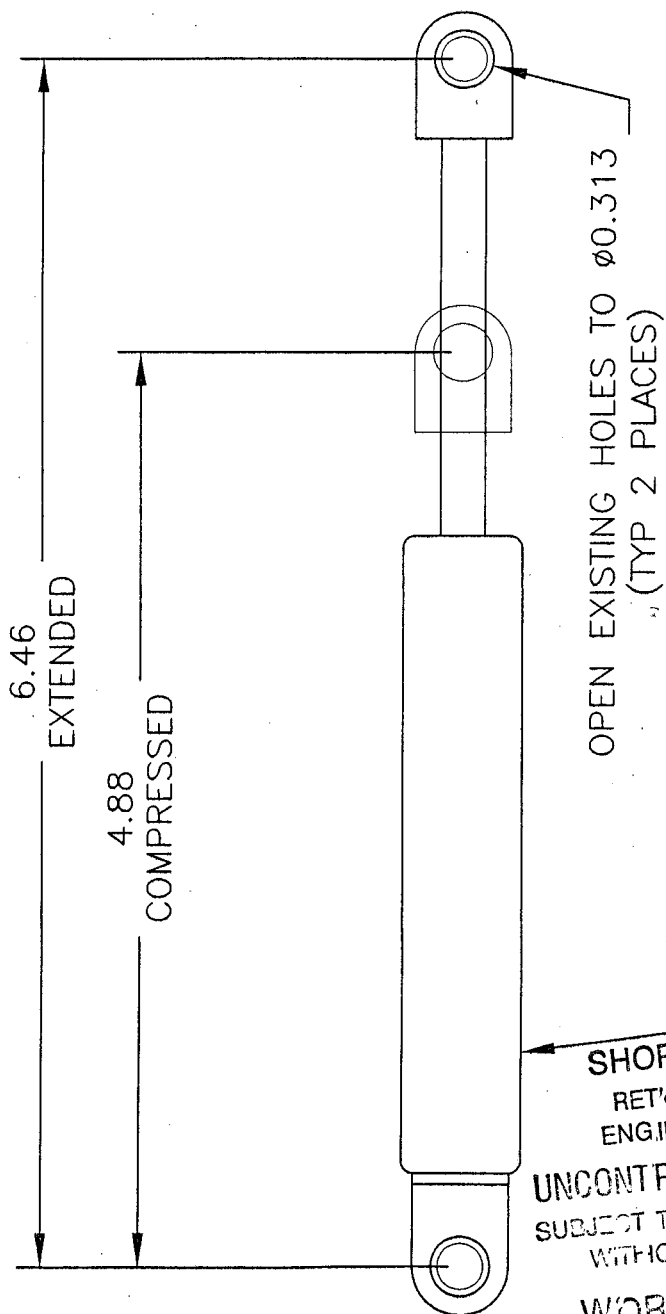
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



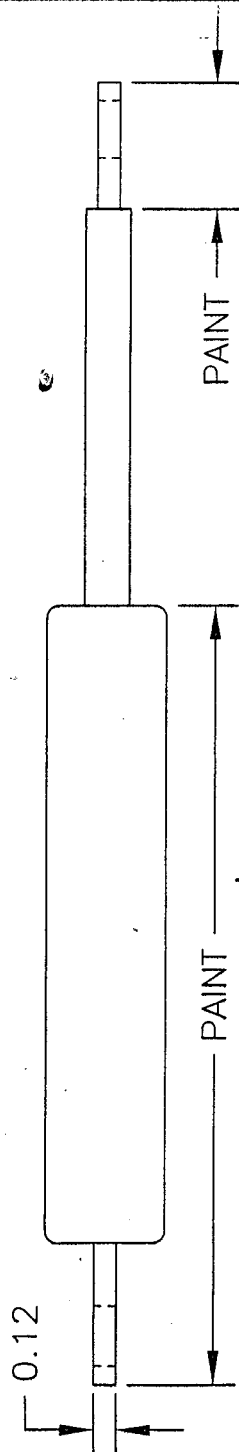
DESIGN DS	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED ///	APPROVED ///	DRAWING NO. D2807	REV. B SHEET 1 OF 1
DATE 05.03.16	TITLE GAS SPRING		SCALE 1:1
A	00.11.03	NEW ISSUE	
B	05.03.16	ADD FINISH	

RELEASED
~~///~~ 05.03.16



REMOVE EXISTING LOGO.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 23479



D2807 GAS SPRING

- 1) POSSIBLE SUPPLIER: SPRING LIFT P/N: SL-4-40 (40 lb LOAD)
ACCEPTABLE LOAD RANGE IS 25 lb MIN TO 45 lb MAX
- 2) FINISH: AFTER DRILLING, IN AREAS MARKED "PAINT" ABOVE: LIGHTLY SAND AND THEN PRIME
AND PAINT USING PLASTI-KOTE "RUST NOT" 391 GREY PRIMER AND PLASTI-KOTE
"SUPER ENAMEL" T-1 GLOSS BLACK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jun 03, 2005
10:33 am

Work Order No : 0023479
Project Name : D2807-3
Project For : WK523
Work Order Type : Main
Main WO Number :
House Part Number : D2807-3
Description : Lug
Manufactured : Yes
Amount Req'd : 100
Amount Done : 0
Start Date : 06-02-05
Est Finish Date : 06-10-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

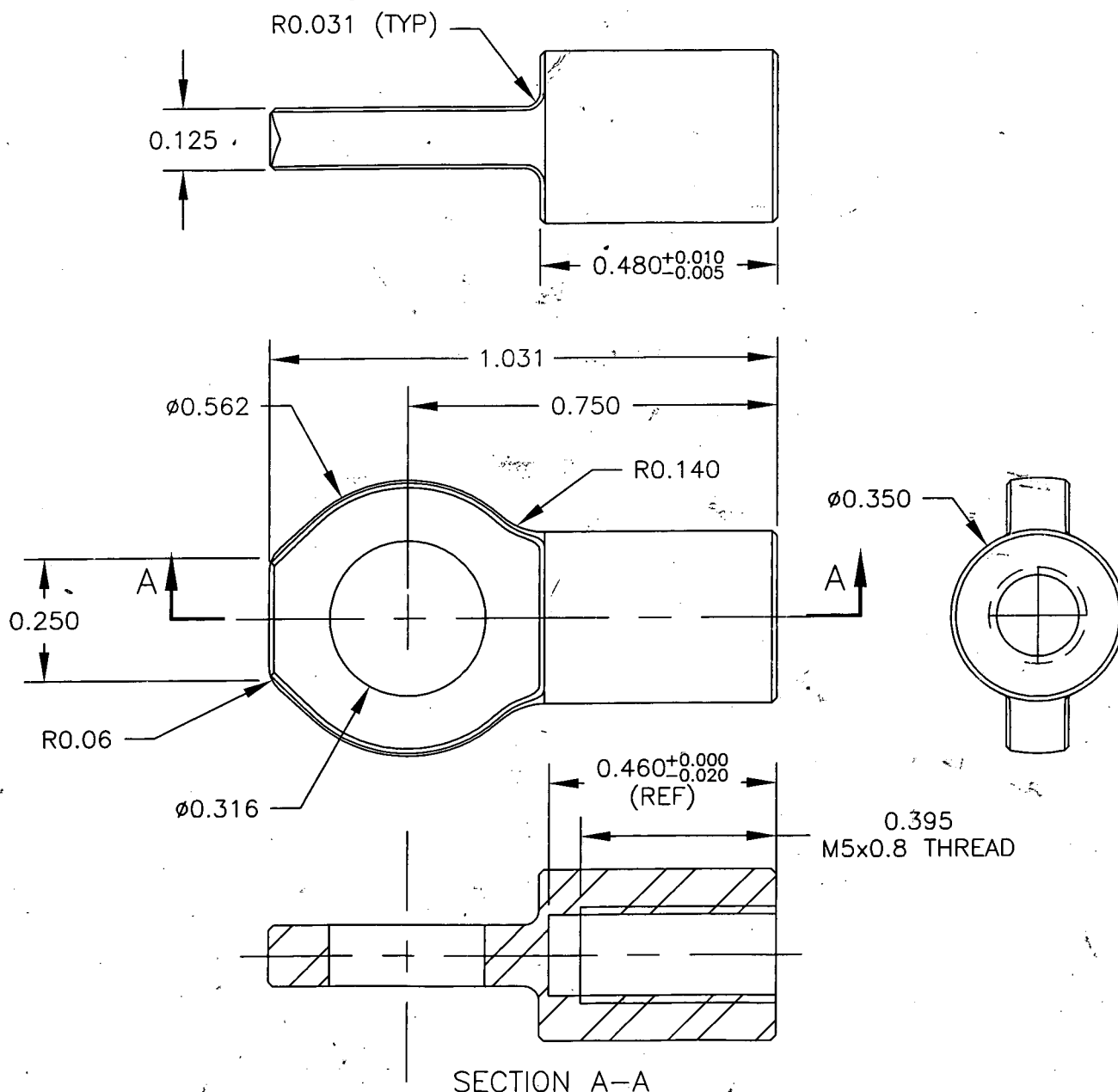
Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

PRELIMINARY ISSUE

DESIGN DS	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2807	REV. C SHEET 2 OF 2
DATE 05.05.25	TITLE GAS SPRING		SCALE 3:1



D2807-3 LUG

- 1) MATERIAL: AISI 303 ROUND BAR (REF DART SPEC. M303R)
- 2) FINISH: NONE
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70.402
12.945

X. 420
Z. 563

2.350
7.470

[Handwritten notes:]

603
x Med 2-5-18 R. 196 F20 S F20
603 x 603 x 603
603



DART AEROSPACE LTD		Work Order: 23479
Description:		Part Number: 02807
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.460	± 0.000 ± 0.020	0.454	✓			
0.350	± 0.005	0.355	✓			
1.031	± 0.005	1.031	✓			
HAAS						
.125	$\pm .010$.123	✓		Vern	
1.031			✓			
.480	$\pm .010$ $\pm .005$.480	✓		Vern	
.250	$\pm .010$.249	✓		Vern	
Ø.316	$\pm .005$ $\pm .001$.320	✓		Vern	
M5X.8						
.750	$\pm .010$.747	✓		Vern	

Measured by: JG/JL	Audited by:	Prototype Approval:
Date: 05/06/09 / 05/06/09	Date:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	